

Work Order ID 63509

Wednesday, November 03, 2010 11:13:18 A

Page 1

Item ID: D350-591-311

Accept

Setup Start

Revision ID:

Stop

Item Name: Heli-Access-Step, Long LH

Start Date: 11/3/2010 Start Qty: 10.00

Cust Item ID:

Required Date: 1/4/2011 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-11-03

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-311 ~~CHG002~~

CHG001 Evaluator stops

8 10/12/17 HJ For BG 10-12-15
(10)

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg

D3272

A/R ☐ Aluminum Rod ☒ M108436

3-Grind End Plate flush M115928

10.12.08

10 of

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63509

Wednesday, November 03, 2010 11:13:18 A

Page 2

Item ID: D350-591-311

Accept

Setup Start

Revision ID:

Stop

Item Name: Heli-Access-Step, Long LH

Start Date: 11/3/2010 Start Qty: 10.00

Cust Item ID:

Required Date: 1/4/2011 Req'd Qty: 10.00

Customer:




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				10	0	BE10/2/08	
130  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				10	0		
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				10	0		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63509

Wednesday, November 03, 2010 11:13:18 A



Page 3

Item ID: D350-591-311

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long LH

Start Date: 11/3/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 1/4/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

QC3- Inspect Part Finish

0.00

2734 10/12/08

10

✓

QC

Memo

0.00

Quality Control

180

Large Fab

0.00

Large Fab

Memo

0.00

10.12.10

10

✓

Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272
A/R ☐ Aluminum Rod ☒ 11/12/08/36

6-Grind End Plate flush

7-Install last rivet as per Dwg.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63509

Wednesday, November 03, 2010 11:13:18 A

Page 4

Item ID: D350-591-311

Accept

Setup Start

Revision ID:

Item Name: Heli-Access-Step, Long LH

Stop

Start Date: 11/3/2010 Start Qty: 10.00

Cust Item ID:

Required Date: 1/4/2011 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

10 0 3E10/12/13

200

QC5- Inspect part completeness to step on W/O

0.00



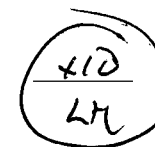
QC

Memo

0.00

Quality Control

8 10/12/13



210

Chemical Conversion Coat per QSI005 4.1

0.00



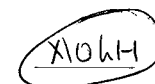
HandFinish

Memo

0.00

Hand Finishing

=> 10/12/13



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63509

Wednesday, November 03, 2010 11:13:18 A

Page 5

Item ID: D350-591-311

Accept

Setup Start

Revision ID:

Stop

Item Name: Heli-Access-Step, Long LH

Start Date: 11/3/2010 Start Qty: 10.00

Cust Item ID:

Required Date: 1/4/2011 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

230

Wing Walk as per dwg QSI005 4.4 Batch

0.00

HandFinish

Hand Finishing

Memo

0.00

240

QC3- Inspect Part Finish

0.00

QC

Quality Control

Memo

0.00

10 BR 10/12-15

X106H

X10
LH

ML 10/12/15

8.012/17

3:15
320°
3:45

9:00
320°
9:30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63509

Wednesday, November 03, 2010 11:13:18 A



Page 6

Item ID: D350-591-311

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long LH

Start Date: 11/3/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 1/4/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
QC	Memo	0.00							
Quality Control									
270	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-591-311								
	Location: <u>B</u>								

11/12/14 200

+10
LHV

11/12/20 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63509

Wednesday, November 03, 2010 11:13:18 A

Page 7

Item ID: D350-591-311

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long LH

Start Date: 11/3/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 1/4/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/21 21
mf
10-12-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Wednesday, November 03, 2010 11:13:22 AM

Page 1





... ..

Barcode

Required Date: 1/4/2011

Required Qty: 10.00

Comments: IPP Rev:A 04.03.22 New issue KJ/RF
IPP Rev:B 07-06-09 Added D3272-1 JLM
IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC
IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3067-1 		Manufactured	No			110	Each	136.0000	1	10		10.12.09	
End Plate													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				136					
					60141			5					
					<u>62664</u>			131		10			
D3219-1 		Manufactured	No			110	Each	61.0000	2	20		10.12.09	
Plate													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA	<u>363551</u>			61		20			
					61204			61					
D3272-1 		Manufactured	No			110	Each	0.0000	1	10		10.12.02	363514
Step													
D3065-041 		Manufactured	No			180	Each	162.0000	1	10		10.12.09	
Step Leg Assembly Hi													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST				134					
					<u>63324</u>			134		10			
				WA				28					
					61216			3					
					<u>62224</u>			25					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, November 03, 2010 11:13:22 AM

Page 2

Work Order ID: 63509

Parent Item: D350-591-311

Parent Item Name: Heli-Acc-ss-Step, Long LH

Start Date: 11/3/2010

Required Date: 11/4/2011

Start Qty: 10.00

Required Qty: 10.00

D3066-1 Manufactured No

180 Each

87.0000 2 20



Spacer

Location

Loc Qty

Loc Code

WA

B63549

87

20

62662

87

D3067-1 Manufactured No

180 Each

136.0000 1 10



End Plate

Location

Loc Qty

Loc Code

WA

136

60141

5

10

62664

131

MS20600-AD4W4 Purchased No

180 Each

1,875.000 16 160



Rivets

Location

Loc Qty

Loc Code

ST321

1875

113368

38

114181

11

114718

2

115573

147

115640

677

116022

1000

160

AN3-35A Purchased No

250 Each

139.0000 2 20



Bolt

Location

Loc Qty

Loc Code

ST353

139

115457

39

115936

100

M116419 10/14/14 SK 160

Wednesday, November 03, 2010 11:13:22 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, November 03, 2010 11:13:22 AM

Page 3

Work Order ID: 63509

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 11/3/2010

Required Date: 1/4/2011

Start Qty: 10.00

Required Qty: 10.00

AN4-13A

Purchased

No

250

Each

413.0000

8

80



Bolt

Location

Loc Qty

Loc Code

ST357

300

115936

300

ST358

113

115159

113

AN5-36A

Purchased

No

250

Each

147.0000

2

20



Bolt

Location

Loc Qty

Loc Code

ST340

100

115936

100

ST341

47

114292

5

114941

42

AN960JD10

NAS1149D0363J

Purchased

No

250

Each

8.0000

4

40



Washer

Location

Loc Qty

Loc Code

ST

6

107715

6

ST335

2

105792

2

AN960JD416

NAS1149D0463J

Purchased

No

250

Each

24.0000

16

160



Washer

Location

Loc Qty

Loc Code

ST300

24

113288

24

Wednesday, November 03, 2010 11:13:22 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, November 03, 2010 11:13:22 AM

Page 4

Work Order ID: 63509

Parent Item: D350-591-311

Parent Item Name: Heli-A-Jess-Step, Long LH

Start Date: 11/3/2010

Required Date: 1/4/2011

Start Qty: 10.00

Required Qty: 10.00

AN960JD516 NAS1149D0563J Purchased No

250 Each

34.0000 4 40



Washer



M/14742 10/12/14 SP

Location

Loc Qty

Loc Code

Location	Loc Qty
ST	34
103694	18
107534	12
109287	4

D2230-3 Manufactured No

250 Each

90.0000 4 40



Lug



B63992 10/12/14 SP
B63312 32 10/12/14 SP

Location

Loc Qty

Loc Code

Location	Loc Qty
ST476	90
55452	2
62660	88

D2618 Manufactured No

250 Each

153.0000 2 20



Bushing



B63548 10/12/14 SP

Location

Loc Qty

Loc Code

Location	Loc Qty
ST019	151
60772	51
62213	100
ST020	2
56892	1
57829	1

Wednesday, November 03, 2010 11:13:22 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, November 03, 2010 11:13.22 AM

Page 5

Work Order ID: 63509

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 11/3/2010

Required Date: 1/4/2011

Start Qty: 10.00

Required Qty: 10.00

D2856-400 220 7.20" long Manufactured No

250

f

175.2500

0.6

6



11/12/14 SP

Abraison Strip

Location

Loc Qty

Loc Code

ST403

175.2500421

56626

0.00004211

59920

175.25

D3235-1 Manufactured No

250

Each

57.0000

2

20



B6354710/12/14 SP

Mounting Lug

Location

Loc Qty

Loc Code

ST471

57

60851

20

61845

37

D3278-041 Manufactured No

250

Each

62.0000

1

10



64731 11/14/17

Support Assembly

Location

Loc Qty

Loc Code

ST471

62

61212

32

62395

30

MS21042L3 Purchased No

250

Each

1,890.000

2

20



M116373 11/12/14 SP 102

Nut

Location

Loc Qty

Loc Code

ST300

1890

114784

890

115835

1000

5

Wednesday, November 03, 2010 11:13:22 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 6

Wednesday, November 03, 2010 11:13:22 AM

Work Order ID: 63509



Parent Item: D350-591-311



Parent Item Name: Heli-Access-Step, Long LH

Start Date: 11/3/2010

Required Date: 1/4/2011

Start Qty: 10.00

Required Qty: 10.00

MS21042L4

Purchased

No

250

Each

2,781.000

8

80



10/12/10

8 #0 Nut

Location

Loc Qty

Loc Code

ST300

2781

113422

25

114523

8

115589

1648

115621

1100

MS21042L5

Purchased

No

250

Each

747.0000

2

20



11/6/10 10/12/10 10x

7 #0 Nut

Location

Loc Qty

Loc Code

ST139

26

114813

26

ST300

721

115156

221

115594

500

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>GP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.04 *H*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET



GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *63509*
PL 10-11-03

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

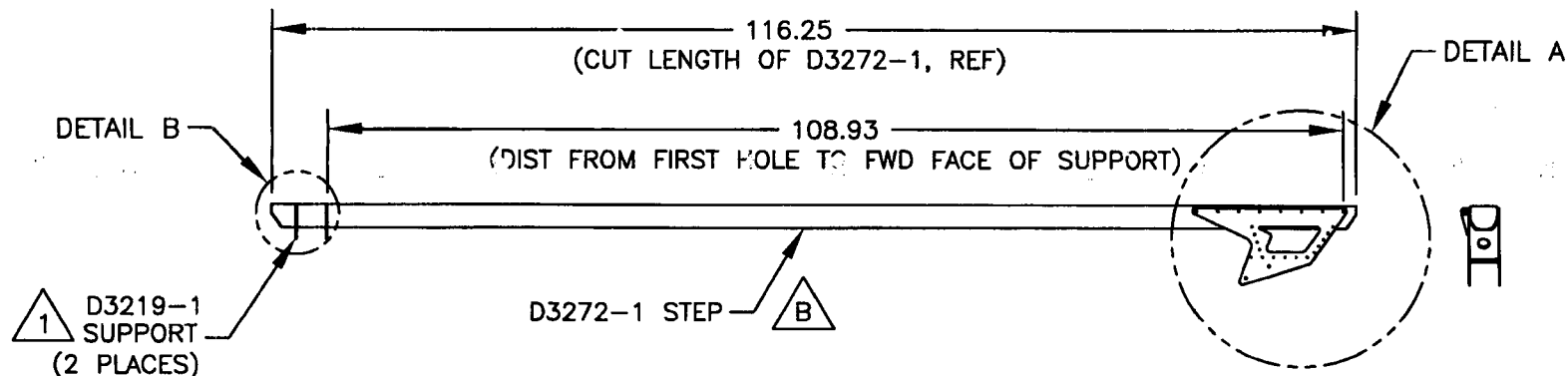
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

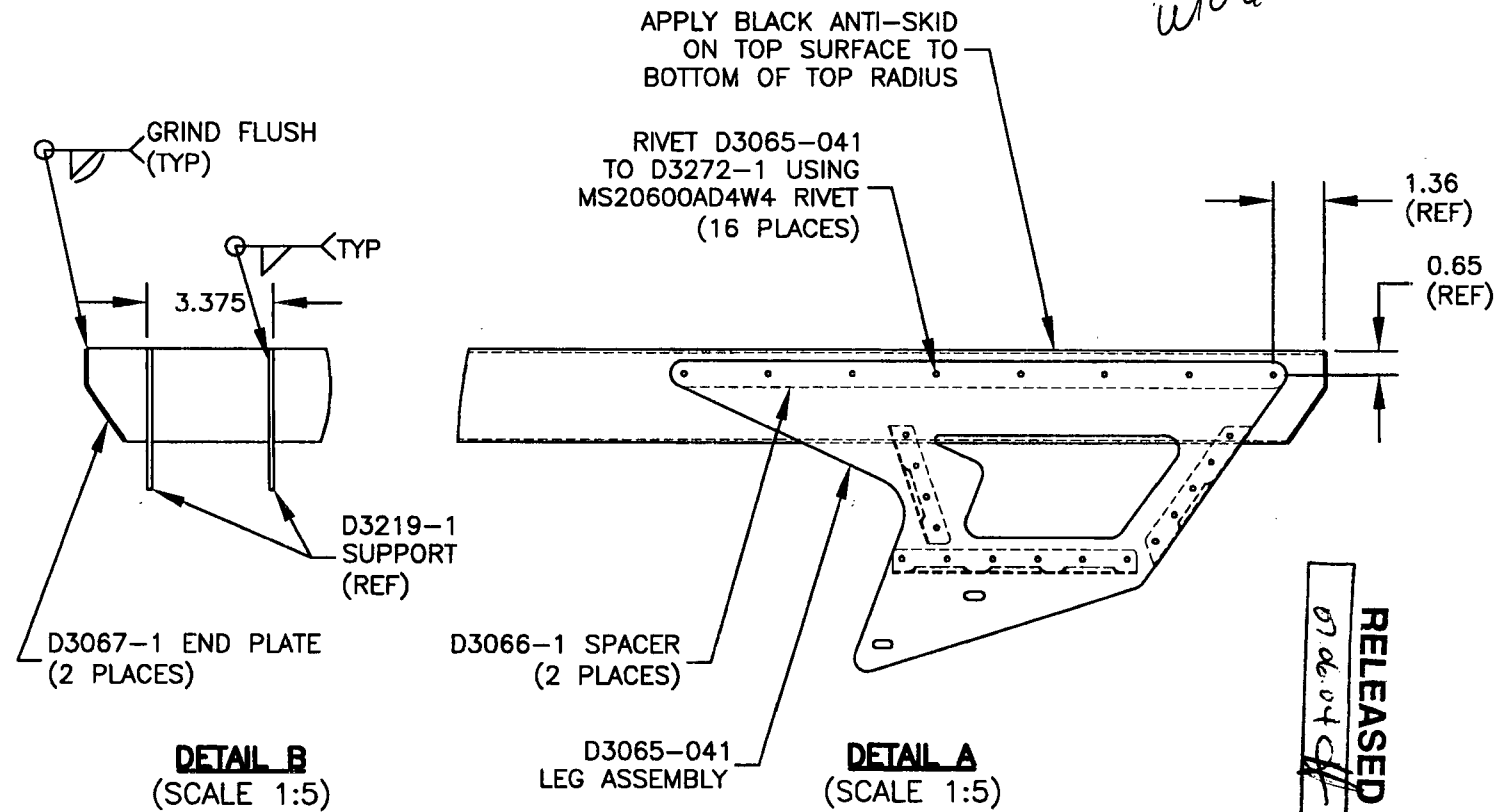
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)

W063509



DESIGN	W063509	DRAWN BY	JR	DART AEROSPACE LTD
CHECKED	CE	APPROVED	JR	HAWKESBURY, ONTARIO, CANADA
DATE	07.05.18	DRAWING NO.	D3272	REV. B
		TITLE	STEP ASSEMBLY, HI LONG	SHEET 2 OF 3
				SCALE 1:20

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Copyright © 2004 by DART AEROSPACE LTD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

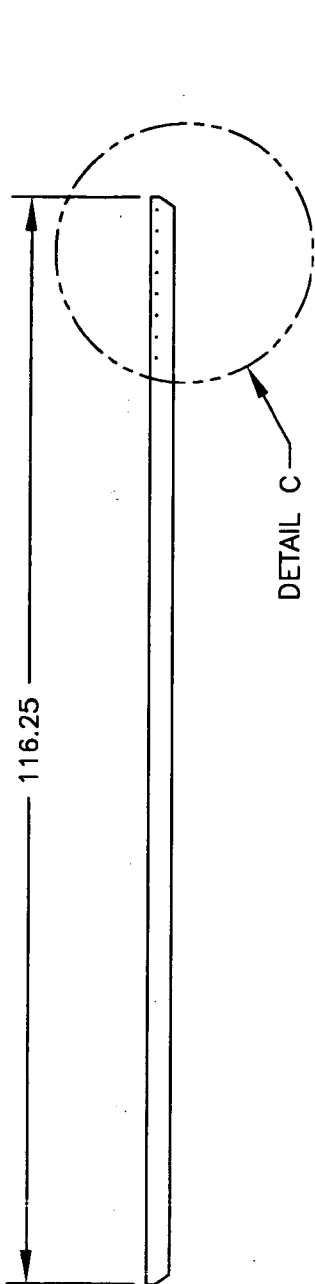
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

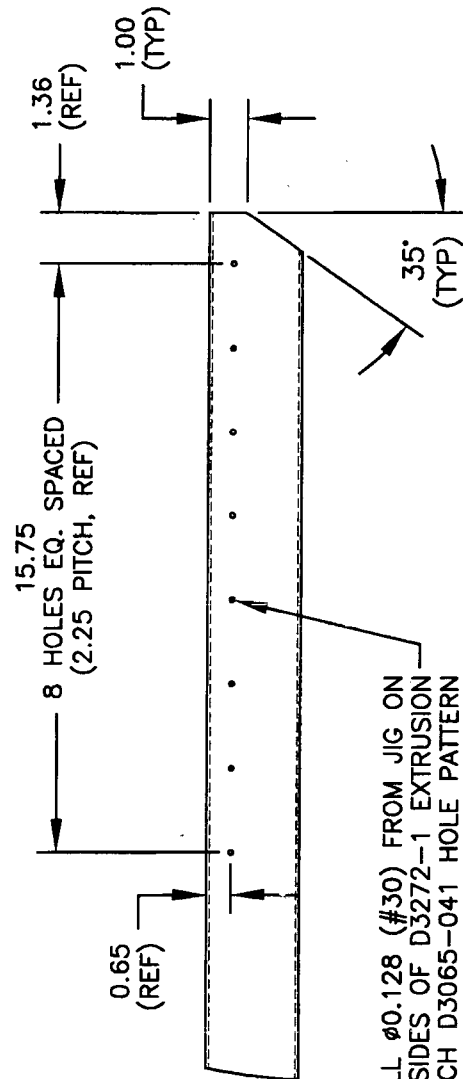


DESIGN <i>qp</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20



Job 63509

B D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)



DETAIL C
(SCALE 1:5)

RELEASED

07.06.04 *[Signature]*

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

DART AEROSPACE LTD.

D350-591
Page 23 of 23

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™, Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™, Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.